0.00

0.00

0.00

0.00

Chemical Conversion Coat per QS1005 4.1

STRIP SADDLES

QC7-Inspect Chemical Conversion Coat

Memo

Memo

190

195

QC

\*190\* **HandFinish** 

Hand Finishing

Quality Control

Page 1

Insp.

2x9 m-f 13/08/19

												DQA:	Date	e:
NCR: \	'es	/ No					WORK ORDER NON-	COI	NFORM	MANCE / UP	PDATE	04.61		
						_						QA Closed:	Date	e:
Work Orde	r:						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
						1	Rework			Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.					ı	Scrap			Machining Small Fab			d. Eng. Coor.	Quality
	•						Use-as-is	1	Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo.					1	Work Order Update	]		Large Fab	Composite	]	Supplier	
Root	_		· · · · · · · · ·		Desc	ript	iption of work order update			Ac	ction	Sign &		
Cause		Date	Step	Qty		-	Non-conformance	1	ief Eng		cription	Date	Verification	QC Inspector
oc/Data				1							•			
quip/Tooling														
perator			İ							•				
laterial														
etup														
ther														
rocess				]										
upplier			İ											
raining		]	ļ											
napproved								<u> </u>					<u> </u>	
							<u></u>	AUI	T CATE	GORY				
Landi	ng (	Gear			_	_	General	_	,		_	_	_	
		Bending			<u> </u>	_	Bend	ļ	Grain		j	Ovalized	<u> </u>	Pressure/Forced
		Centre No	ot Conce	ntric to (	o/s	_	BOM/Route	<u> </u>	Hardwa		-	Over/Under	<b>—</b>	Temperature/Cure
		Cracks				_	Broken/Damaged	<u> </u>	1 '	on Incomplete	,, ,	Part Incorre	F	Weld
	_	Crushed/	Crimped		-		Burrs	_	4	ions Incomplete,	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs	_				Contamination	$\vdash$	Mainte			Part Moved	•	
	_	Heat Trea	-	T b =			Countersink	$\vdash$	Mislabe		-	Positioned V		Other
		Inspection	-	Tube	-		Cut Too Short	$\vdash$	Misread	1	Ĺ	Power Loss/	onige [	Other
		Ripples in		* <b>.</b>	_	_	Drill Holes	-	Offset	Calibratic -				
İ	_	Torque W			n	$\neg$	Drawing Siminh	$\vdash$	-1	Calibration				
	l	Turning S	eauence			- 11	Finish	1	TOUT OF S	Sequence				

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Packaging

DQA: Da	ate:
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NCR: Yes / No

### **WORK ORDER NON-CONFORMANCE / UPDATE**

	,										QA Closed:	Da	ite:	
Work Ordei	,,			•	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
Part No.					Rework Scrap Use-as-is		Skid-tube Crosstube Machining Small Fab Thermoforming Finishing			Water Jet Prod. Eng. Coor. Rec/Store/Packaging				Engineering Quality Other
NCR No.					Work Order Update Large Fab				Composite			Supplier		
Root	Desc				ption of work order update	Ī	Initial Action				Sign &			
Cause	Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
oc/Data														
quip/Tooling														
Operator														
/laterial	_											-		
etup														
Other														
rocess														
Supplier														
raining														
Inapproved				i		<u> </u>			- <del></del> _					
					F	AUL	T CATE	GORY						
Landin	g Gear				General	_			,		7			1
_	Bending				Bend		Grain				Ovalized		Щ	Pressure/Forced
ļ.,	Centre No	ot Conce	ntric to (	o/s	BOM/Route		Hardwa		ļ		Over/Under			Temperature/Cure
L	Cracks				Broken/Damaged		1	ion Incomplete			Part Incorre			Weld
L	Crushed/	Crimped		L	Burrs		Instruct	ions Incomplete/	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
L	Cuffs				Contamination	$\vdash$	Mainte				Part Moved			
L	Heat Trea	at			Countersink		Mislabe		ļ		Positioned V	-		1
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	d	Į		Power Loss/	Surge		Other
	Ripples in	Bend		L	Drill Holes		Offset							
	Torque W	/aves in E	Extrusion	ո 📙	Drawing		Out of (	Calibration						····
	Turning S	equence			Finish	L	Out of !	Sequence						
[	Wave/Tw	ist in Tub	эе		Folio		Outside	Dimensions						

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Work Orde Tuesday, July 23						Page 3						
Item ID: Revision ID: Item Name:	D3883-1 Saddle, Outbo	oard LH		Accept	*N900	<u>040</u>	100	)*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	7/23/2013 7/26/2013 REWORK	Start Qty: 2.00 Req'd Qty: 2.00	*2* *2*		Cust Item l Customer:	D:						
Approvals:	Process Pla	nn:	Date:	Tooling: SPC (Y/N):		ate:	-		Run	Start Stop	*NI *NI	R1* R2*
Sequence ID/ Work Center II 220	)	Operation Description QC21- Final Inspection -	Work Order Release	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty	•	Reject Number	Insp. Stamp
*22U*		Memo		0.00				h	UT.	_13-	<u>08-</u> Z	Z

Quality Control

Mr. 85 2

DQA:	Date:

#### **WORK ORDER NON-CONFORMANCE / UPDATE**

Yes / No NCR: QA Closed: Date: DISPOSITION **AGAINST DEPARTMENT/PROCESS** Work Order: Skid-tube Crosstube Water Jet Engineering Rework Prod. Eng. Coor. Part No. Machining Small Fab Quality Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Work Order Update Large Fab Composite Supplier Description of work order update Action Sign & Initial Root Chief Eng QC Inspector Qty or Non-conformance Description Verification Date Step Date Cause Doc/Data Equip/Yooling Operator Material Setup Other Process Supplier Training Unapproved **FAULT CATEGORY Landing Gear** General Bending Bend Grain Ovalized Pressure/Forced Temperature/Cure Centre Not Concentric to O/S BOM/Route Hardware Over/Under tolerance Cracks Broken/Damaged Part Incorrect Weld Inspection Incomplete Wrong Stock Pulled Part Lost/Missing Crushed/Crimped Burrs Instructions Incomplete/Unclear Cuffs Maintenance Part Moved Contamination Countersink Mislabeled Positioned Wrong Heat Treat Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Drill Holes Offset Ripples in Bend Out of Calibration **Torque Waves in Extrusion** Drawing **Turning Sequence Finish** Out of Sequence

**Outside Dimensions** 

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Wave/Twist in Tube

Folio

## **Picklist Print**

Tuesday, July 23, 2013 3:46:13 PM

Work Order ID:

105145

Parent Item:

D3883-1

Parent Item Name:

Saddle, Outboard LH

Start Date: 7/23/2013

Required Date: 7/26/2013

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: New issue DD verified by:EC

Comments.	11 1 100 1111 11011 1111	ac isis veninea isy.i	,0											i
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D3883-1 Saddle, Outboard LH		Manufactured	No				Each	6.0000		2		<del></del> -		-
				<b>Location</b>		Loc Qty	Lo	c Code						
				ST429		6				<del> </del>				
				1022	227	2								- !

99179

2 x 88530

		DQA:	Date:	
ICD: Voc / No	WORK OPDER NON-CONFORMANCE / LIPDATE			

NCR:	Yes	/ No				WORK ORDER NON-C	.Or	NFURI	VIANCE / UP	DATE	QA Closed:	Date	:
Work Orde	ar.					DISPOSITION				AGAINST DE	PARTMENT,	/PROCESS	
Work Order: Part No. NCR No.						Rework Scrap Use-as-is Work Order Update	ı	Skid-tube Crosstube Machining Small Fab Thermoforming Finishing Large Fab Composite			Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
Root					Descri	ption of work order update	ı	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty	[	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
				<u> </u>	1	F	AUL	T CATE	GORY				· · · · · · · · · · · · · · · · · · ·
Landi	ng (	Gear				General			-				
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion			Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Grain  Hardware Inspection Incomplete Instructions Incomplete/Unclear Maintenance Mislabeled Misread Offset Out of Calibration			Ovalized Pressure/Forced Over/Under tolerance Temperature/Cure Part Incorrect Weld Part Lost/Missing Wrong Stock Pulle Part Moved Positioned Wrong Power Loss/Surge Other				
	$\vdash$	Turning S			'' <u> </u>	Finish	Out of Sequence						

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

# RA 111452 D119-646-211 B91555

Received @ Dart December 18th, 2012 Inspected@ Dart December 19th, 2012

Customer: AGUSTA WESTLAND Customer Contact: MATTHEW PIAZZA Shipped from: PHILADELPHIA PA, USA

#### Instructions for RA111452 D119-646-211 B91555 CHG003

- Remove both wear plates D3849-041 & D3849-043 and return back to stock under-new batch #'s no reworks needed Cyringen at postal number
- D119-646-241 B91574 was returned
- Out of the kit only these D parts were returned
  - MUST BE RETURNED TO STOCK UNDER NEW BATCH #'S
  - Only D3884-1 B91551 qty x2 returned
    - Needs powder coat striped and re powder coated
  - Only D3883-1 B88530 qty x2 returned
    - Needs powder coat striped and re powder coated
  - o Only D3407-041 B88212 qty x1 returned
    - Needs powder coat striped and re powder coated
  - Only D3886-041 B88235 qty x2 was returned form D119-646-311 B87632
    - Needs powder coat striped and re powder coated
  - No hardware was returned
- D119-646-241 B91574 saddles do not align and could be saved by approved re work scheme that must be approved by David Shepard or skid tube is scraped

<u>Time Estimate</u> =? HOUR ONLY (stores)

Departments Required: Stores (restocking)

<u>Pictures Attached</u> = YES

**QTY INSPECTED** = QTY x1 D119-646-241 and some D parts

THIS INSTRUCTION SHEET MUST BE ATTACHED TO THE RESTOCKING WORK ORDER AT ALL TIMES!!!!

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